

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028197**Date Inspected:** 16-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

OBG 12W (Interior)

This QA observed the following welders working in OBG 12W at various locations:

Authorized welder Chris Bruce #8901:

Welder Chris Bruce was observed welding on welds 12W PP116 W2.1-PS2 (1G & 4G, CJP), weld 12W PP116 W2.1 PS4 (1G & 4G, CJP), weld 12W PP116.5 W2.1-BW3(1G & 4G, CJP) and on weld 12W PP116.5 W2.1 PS4 (1G & 4G, CJP) utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030 and ABF-WPS-D15-1040A. Welding parameters as per WPS utilized appears to be in order.

Authorized welder Chau Tran #3139:

Welder Chau Tran was observed welding on the welds 12W 13W LS3S DSF (4G, PJP) and 12W 13W LS3N DSF (4G, PJP) attaching the flanges to the deck rib stiffeners to LS3. Welder Chau Tran was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1162-4 following pre heat protocols with a heat blanket placed to heat the deck stiffener and attachment flanges. Once the flanges and stiffeners reached a pre heat temperature of 250 degrees Fahrenheit the welder commenced welding the 4G weld for attaching the flanges. After completion of the welding Mr. Chau Tran was observed grinding the weld flush.

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OBG 12W (Exterior)

Authorized welder Eric Sparks #3040:

Welder Eric Sparks was observed making weld repairs to weld 12W 13W A1.1 at Y location 330. This is a first time repair for this Y location of an indication found by Ultrasonic Testing (UT) and no RWR was required.

Welder Eric Sparks was observed making repairs to weld 12W 13W A1.2 at Y location 1720. Porosity was noticed after grinding the weld cap smooth in preparation for Ultrasonic Testing (UT). A repair was necessary. This is the second repair at Y location 1720 and an RWR was required but none was presented to this QA prior to commencement of repairs. QC Chris Conche was notified of lack of RWR. Both repairs were completed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1004-Repairs and welding parameters as per WPS utilized appears to be in order.

This QA randomly observed OBG 12W QC Chris Conche, checking fit up of various welds, and checking WPS compliance of welders throughout the day and performing Magnetic testing (MT) on back gouges as they become available for testing.

Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on the following welds:

Weld 12W 13W A1.1:

- MT of Indication Repair at Y location 330 (80 x 20 x 14 Deep, MT Accept.)

Weld 12W 13W A1.2:

- MT of Indication Repair at Y location 1720 (120 x 23 x 8 Deep, MT Accept.)

Weld 12W PP116.5 W2.1-PS4:

- MT Back Gouge (100mm, MT Accept.)

Weld 12W PP116.5 W2.1 BW3:

- MT Back Gouge (210mm, MT Accept.)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Conversations relevant to work performed on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy - (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
